

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003277**Date Inspected:** 11-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yanhua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

**Bay 3 – Heavy Duty Machinery Shop**

The QA Inspector observed ZPMC qualified welder Dong Hu Yong Cang ID 203805 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP051-001.

The QA Inspector Dixon was informed by ZPMC QC Inspector Mr. Shen Xuejun that ZPMC CWI Inspector Li Yen Hua and ABF personnel Kevin Chen were about to perform a final three party visual repair inspection on deck panels DP026-001, DP031-001, and DP066-001.

Mr. Wang Lu Then requested that a Caltrans QA Inspector also performed a visual inspection on the deck panels.

The QA Inspector observed ZPMC magnetic particle technician Bo Pin Rin performs (MT) prior to repair welding on the following deck panels: DP073-001, DP076-001 and DP079-001.

The final visual inspections performed on the above listed deck panels generally appeared to conform to contract specifications.

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## WELDING INSPECTION REPORT

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OBG Bay #1

The QA Inspector inspected deck panel tack welds on DP332-001 at Gantry # 1 and observed 82 cracked tack welds which ZPMC personnel had found during a Magnetic Particle Inspection and had marked the U-rib numbering each indication found.

The QA Inspector verified the length of the indications. ABF personnel Wang Zhen Hua was also present to verify the cracks in the tack welds.

### Summary of Conversations:

As noted within the report shown above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Dixon,Roscoe | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Cochran,Jim  | QA Reviewer                 |

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